

Date: Tuesday, 1/16/2007 11:28:56 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT
Job Number : 30276B	
Estimate Number : 10462	
P.O. Number : N/A	Part Number : D32782
This Issue : 1/16/2007 S.O. No. : N/A	Drawing Number : D3278 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 30150B	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 1/26/2007 Qty: 40 Um: Each
Checked & Approved By : <u>[Signature]</u> 01.01.16	
Comment : Est:A 04.04.19 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M6061T6B1000X02000	6061-T6 Bar 1.0" x 2.0"
-----	--------------------	-------------------------



Comment: Qty.: 0.2454 f(s)/Unit Total : 9.8154 f(s)

Material: 6061-T6/T651 (QQ-A-200/8) 1.00" thick
 (M6061T6B1.000x02.000)

Batch: M19295

J.L 07/01/21

2.0	SHEAR	SHEAR
-----	-------	-------



Comment: SHEAR SAW

Cut blank: 2.00" x 1.00" x 2.550" long

J.L 07/01/21

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA405 and Dwg D3278
 2- Deburr and Tumble
 Identify as D3278-2

J.L 07/01/22

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 07/01/22

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

J.L 07/01/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/01/22	3	* 2 parts scrapped - 1 part pulled out of jig while machining - 1 part part is too thin	 05/04/22	- scrap + replace - destroy	J.L. 07/01/22	 07/01/22	 05/04/22	 07/01/22

NOTE: Date & initial all entries

Date: Tuesday, 1/16/2007 11:28:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT

Job Number: 30276B

Part Number: D32782

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

YL

07/01/24 x 40

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

FL/YL

07/01/24 (40)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 7/1/25 (40)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5418

FL 07/01/25 (40)

FL

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(40)

Comment: FINAL INSPECTION/W/O RELEASE

07/01/26

Job Completion



W 07/01/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 30276B
Description: Support		Part Number: D3278-2
Inspection Dwg: D3278	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	.099	✓			
0.359	+/-0.005	.360	✓			
.609-0.615	+/-0.010	.616	✓			
0.250	+/-0.010	.250	✓			
1.480	+/-0.005	1.480	✓			
R0.125	+/-0.010	r.125	✓			
0.119	+0.005/-0.004	.124	✓			
2.439	+/-0.010	2.440	✓			
1.980	+/-0.010	1.981	✓			
R0.130	+/-0.010	r.130	✓			
Ø0.257	+0.005/-0.000	.259	✓			
R0.375	+/-0.010	r.375	✓			
0.875	+/-0.010	.875	✓			
0.500	+/-0.010	.500	✓			
R0.400	+/-0.010	r.400	✓			
1.720	+/-0.010	1.722	✓			
R0.125	+/-0.010	r.125	✓			
0.125	+/-0.010	.128	✓			

Measured by: J.L.	Audited by: [Signature]	Prototype Approval: N/A
Date: 07/01/21	Date: 07/01/21	Date: N/A

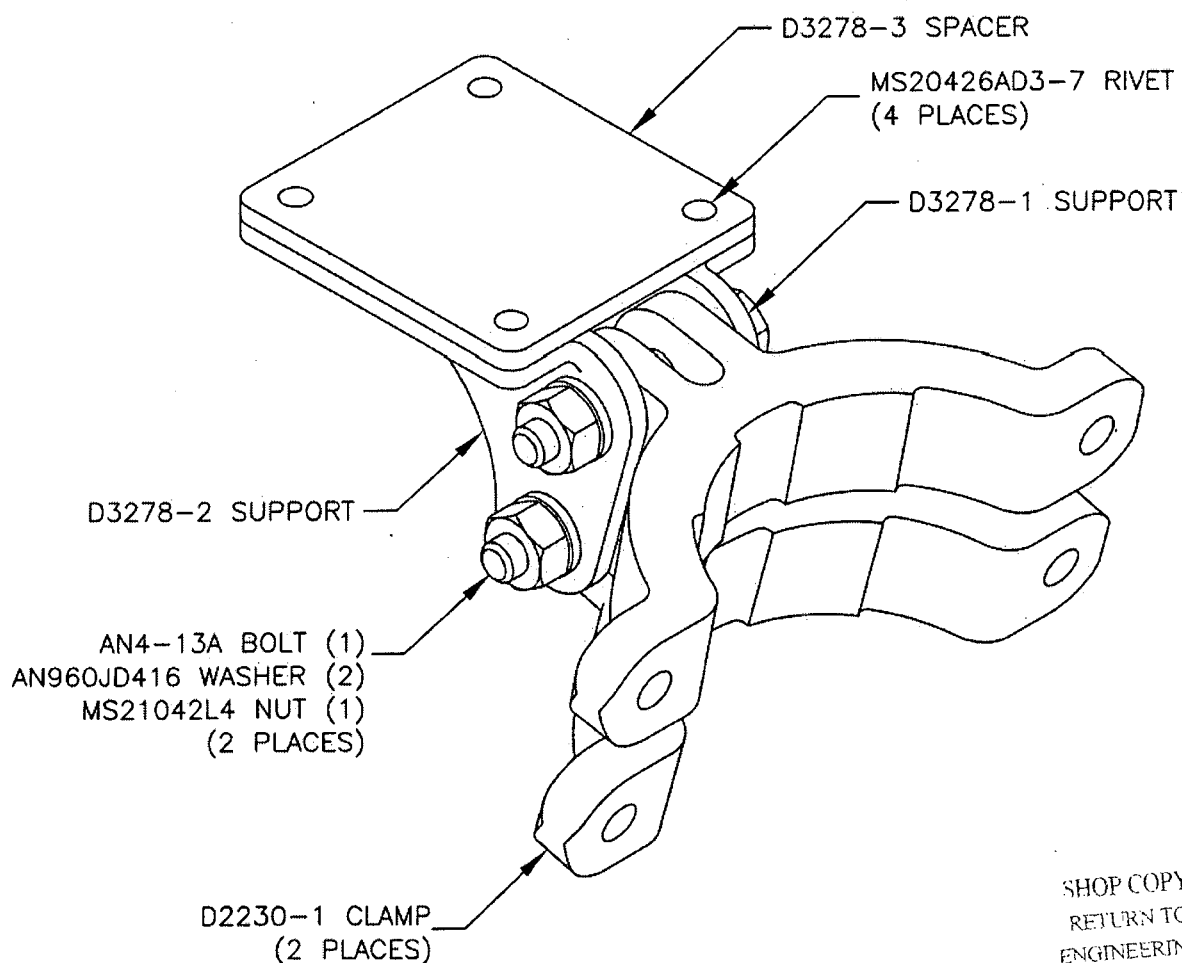
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	[Signature]



DESIGN	CP	DRAWN BY	CP	DART AEROSPACE LTD	REV. 8
				HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	DRAWING NO. D3278	SHEET 1 OF 3
DATE	05.03.31	TITLE	SUPPORT ASSEMBLY	SCALE	NTS
A	04.03.03	NEW ISSUE			
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT			

RELEASED
05.04.04 *[Signature]*

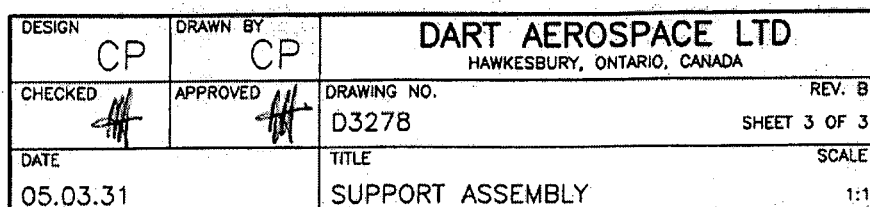
D3278-041 SUPPORT ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30276B

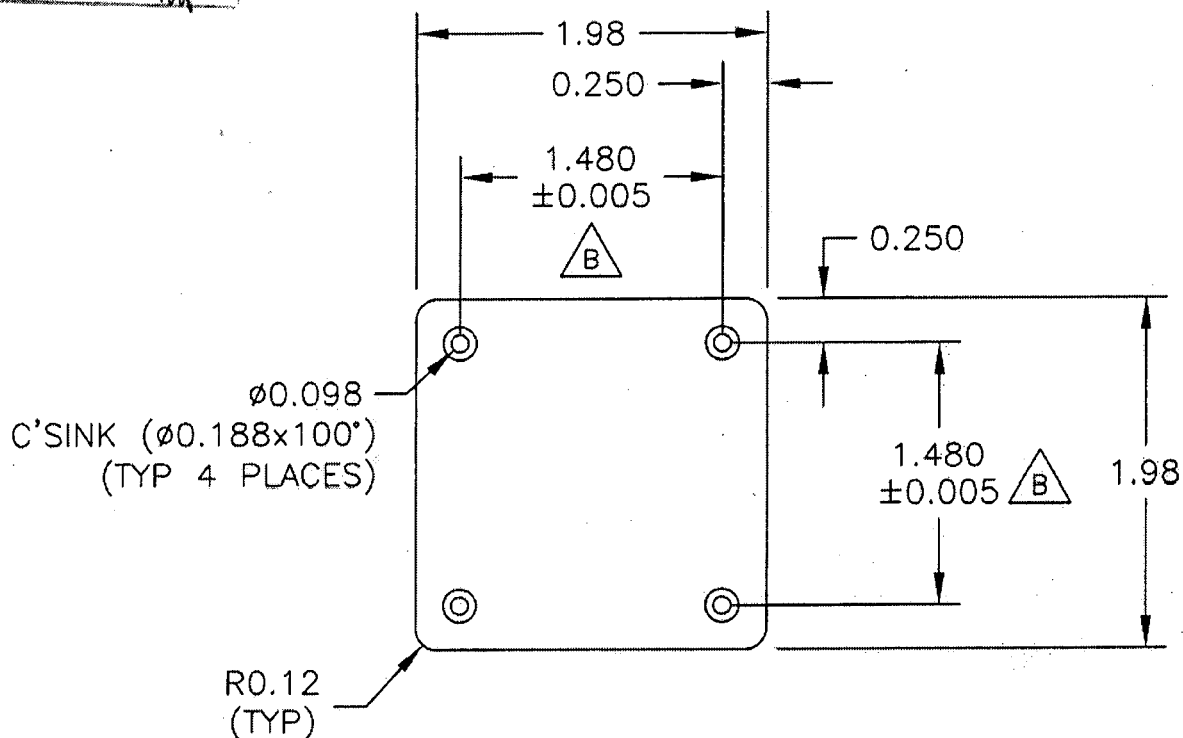
Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



RELEASED

05.04.04



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30276B

D3278-3 SPACER

- 1) MATERIAL: BLACK DELRIN / UHMW PER DART SPEC M-DELRIN-B OR M-DELRIN-S
0.125 THICK
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) ALL DIMENSIONS ARE IN INCHES.

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.